

Date: Monday, 07/04/2008 11:46:54 AM
 User: Julie Lecoq

Process Sheet

| | | | |
|----------------------------------|------------------------------------------------------------------------------------------------------------------------------|-------------------------|-------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : STEP (CASTING DETAIL) |
| Job Number | : 38420 | | |
| Estimate Number | : 11088 | | |
| P.O. Number | : | Part Number | : D25761 |
| This Issue | : 07/04/2008 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D2576 REV G |
| First Issue | : / / | Project Number | : N/A |
| Previous Run | : 33320 | Drawing Revision | : G |
| | Type : PURCHASED PARTS | Material | : |
| Written By | : | Due Date | : 14/04/2008 |
| Checked & Approved By | : <u>JD 08.04.06</u> | Qty: | 100 Um: Each |
| Comment | : Est Rev: A New Issue 05-11-29 JLM est rev B rev F dwg 07.07.06 EC Est Rev:C As per Rev G 07-09-05 JLM Verified By:EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|



Comment: PURCHASING

Issue P/O: 6082

Ship D2576 mould to vendor

Cast per D2576-1 Pattern

Material Release Note Required

C208104107

(100)

| | | |
|-----|---------|-----------------------|
| 2.0 | D25761P | Step (Casting Detail) |
|-----|---------|-----------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 STEP

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure D2576 mould is returned with the ordered parts

Ensure release note is attached

R 8/4/20

(100)

| | | |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

J.L 08/05/23

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Date: Monday, 07/04/2008 11:46:54 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP (CASTING DETAIL)

Job Number: 38420

Part Number: D25761

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



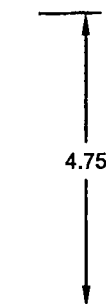
Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

Job Completion

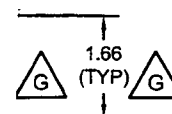


MF 08-05-27



3


K 1.28 SLOT



RELEASED

07.08.29

| | | | |
|------|--------------------------------------------------------------------------------------------------------------|----|----------|
| G | - CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM | MB | 07.08.15 |
| F | 7.05 WAS 6.61 | PH | 07.04.17 |
| E | CHANGE 0.50 HOLE LOCATION AND ADD NOTE | RF | 99.09.07 |
| D | CHANGE SLOT SIZE AND LOCATION (TSR A1069) | CP | 99.08.18 |
| C | ADD POCKETS AND SLOTS FOR WELDING | DS | 98.08.18 |
| B | REMOVE POCKETS, ADD HOLE | DS | 96.11.28 |
| A | NEW ISSUE | DS | 96.09.18 |
| REV. | DESCRIPTION | BY | DATE |

| | | | |
|------------|---------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN |  | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D2576 | SHEET 1 OF 1 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | STEP | | 1 |
| DATE | 07.08.15 | COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

ALPINE NON-FERROUS FOUNDRY8657-132ND STREET
SURREY, B.C. V3W 4P1**WORK ORDER**

Tel: (604) 596-8080

Fax: (604) 596-8045

Sold To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ONT K6A 1K7
CANADA**Ship To:** DART AEROSPACE

| Order Date | | Purchase Order# | Due Date | Ship Via | | P |
|--------------------------------------------------------------------------------|------------|-----------------|-------------|----------|-----|-----|
| 07-Apr-2008 | | PO00006082 | 25-Apr-2008 | FEDEX | | |
| Item# | Item Code | Description | Material | Ordered | B/O | Qty |
| 1 | DART D2576 | D2576 STEP CSTG | | 100 | | |
| 2 | | | | | | |
| Comments Castings&Patterns are property of Alpine until paid in full | | | | | | |

Apr. 23/08

CERTIFICATE OF ANALYSIS

CUSTOM ALLOY LIGHT METALS
13329 ECTOR STREET CITY OF INDUSTRY, CA 91746
PH# (626) 369-3641 FAX# (626) 369-2471

CUSTOMER:

RYPAC ALUMINUM
11849 TANNERY ROAD
SURREY BRITISH COLUMBIA,

SHIP DATE

MAR 03 2008

CONFORMS TO ASTM SPECIFICATION: B179-06

Alloy: 535.2

Heat: A7880

| | |
|-----|-----------|
| Si | 0.060 |
| Fe | 0.057 |
| Cu | 0.007 |
| Mn | 0.128 |
| Mg | 6.990 |
| Cr | 0.001 |
| Zn | 0.011 |
| Ti | 0.135 |
| Sn | 0.003 |
| Pb | 0.001 |
| Ni | 0.000 |
| OET | < .15 |
| Sr | 0.000 |
| Al | REMAINDER |

| | |
|-----|-----------|
| Si | .10 |
| Fe | .10 |
| Cu | .05 |
| Mn | .10-.25 |
| Mg | 6.6-7.5 |
| Cr | |
| Zn | .05 |
| Ti | .10-.25 |
| Sn | |
| Pb | |
| Ni | |
| OET | .15 |
| Sr | |
| Al | REMAINDER |

BE .004

BE .003-.007

ELEMENTS LISTED WITHOUT A RANGE, UNDER THE REQUIRED SPECIFICATIONS, ARE MAXIMUM ALLOWABLE PERCENTAGES. SAMPLES ANALYZED ON AN OPTICAL EMISSION SPECTROMETER WITH CURRENT CALIBRATION STATUS. STANDARDS ARE NIST OR ARE TRACEABLE TO NIST.

Ron Zakrzewski

RON ZAKRZEWSKI

LAB MANAGER

FM-12 01 Rev D 12/5/2001

MAR 03 2008

DATE

WARNING: THE BUYER IS ADVISED THAT THIS METAL MAY CONTAIN CREVICES AND HIDDEN RECESSES HOLDING ENTRAPPED MOISTURE. THE METAL SHOULD BE HANDLED AND PROCESSED WITH THIS POSSIBILITY IN MIND. ENTRAPPED MOISTURE MAY CAUSE AN EXPLOSION IF THE METAL IS INTRODUCED INTO A MELTING FURNACE WITHOUT PROPER DRYING.